DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027862
Date Inspected: 28-Jun-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1930
Location: jobsite

CWI Name: Fred Michaels/William Sherwood

CWI Present:	☑ Yes	☐ No		**Inspected CWI report:**	☐ Yes	☑ No	☐ N/A
Rod Oven in Use:	☑ Yes	☐ No	☐ N/A	**Electrode to specification:**	☑ Yes	☐ No	☐ N/A
Weld Procedures Followed:	☑ Yes	☐ No	☐ N/A	**Qualified Welders:**	☑ Yes	☐ No	☐ N/A
Verified Joint Fit-up:	☑ Yes	☐ No	☐ N/A	**Approved Drawings:**	☑ Yes	☐ No	☐ N/A
Approved WPS:	☑ Yes	☐ No	☐ N/A				
Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A				

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

This QAI observed Damian LLammos of Spencer Mechanical fitting, tacking and welding a butt splice in 2.5" pipe at PP115 West. Llammos ground a bevel on the end of the pipe using a four inch grinder, then using a shim the 1/16" root gap was set. The two pipe pieces were then tacked together to hold the prescribed root gap and proper alignment.

At the conclusion of tack weld and fitting, Mr Llammo began depositing the finished weld metal into the butt joint utilizing the Shield Metal Arc Welding Process to the Quality Control recorded Quality assurance verified parameters of Welding Procedure Specification 1-12-1. Quality Control Inspector Steve Jensen and this QAI performed a visual weld inspection on the finished joint. No rejectable indications noted.

This QAI observed Damian LLammos of Spencer Mechanical fitting, tacking and welding a elbow top.5" pipe at PP115 West. Llammos ground a bevel on the end of the pipe using a four inch grinder, then using a shim the 1/16" root gap was set. The two pipe pieces were then tacked together to hold the prescribed root gap and proper alignment

At the conclusion of tack weld and fitting, Mr Llammo began depositing the finished weld metal utilizing the Shield Metal Arc Welding Process to the Quality Control recorded Quality assurance verified parameters of Welding Procedure Specification 1-12-1. Quality Control Inspector Steve Jensen and this QAI performed a visual

weld inspection on the finished joint. No rejectable indications noted.

OBG 13W-14W West Drop-In

This QAI observed Welder Wen Han Yu (ID#6317) using a rosebud torch to preheat floor beam splice PP121-W2. 4-BW1 to a QC recorded, QA verified temperature of 150F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC Tony Sherwood recording preheat temperature whenever there was a stop in work.

QAI witnessed the welding of Floor Beam Splice PP121-W2.4-BW1 by welder Wen Han Yu (ID#6317) utilizing the Shield Metal Arc Welding Process to the QC recorded QA verified parameters of Welding Procedure Specification ABF-WPS-D15-1030-1.

Mr. Yu completed the first side then back gouged the back side of the weld to sound metal using a 4” angle grinder and power wire brush to clean the back gouge to a bright metal condition.

At the conclusion of back gouging QC Technician William Sherwood performed Magnetic Particle Testing on the back gouged area of the above-mentioned weld at a test frequency of 100% of the weld length. No indications were noted. Upon the completion of Sherwood’s test this QAI performed Magnetic Particle Testing on the weld at a frequency of 10% the total weld length. No indications noted.

QAI witnessed the welding of Floor Beam Splice PP121-W2.4-BF1 by welder Win Han Yu (ID#6317) utilizing the Shield Metal Arc Welding Process to the QC recorded QA verified parameters of Welding Procedure Specification ABF-WPS-D15-1030-1.

Mr. Yu completed the first side then back gouged the back side of the weld to sound metal using a 4” angle grinder and power wire brush to clean the back gouge to a bright metal condition.

At the conclusion of back gouging QC Technician William Sherwood performed Magnetic Particle Testing on the back gouged area of the above-mentioned weld at a test frequency of 100% of the weld length. No indications were noted. Upon the completion of Sherwood’s test this QAI performed Magnetic Particle Testing on the weld at a frequency of 10% the total weld length. No indications noted.

QAI witnessed the welding of Floor Beam Splice PP123-W2.8-BF3 by welder Tran Chau utilizing the Shield Metal Arc Welding Process to the QC recorded QA verified parameters of Welding Procedure Specification ABF-WPS-D15-1030-1.

Mr. Chau completed the first side then back gouged the back side of the weld to sound metal using a 4” angle grinder and power wire brush to clean the back gouge to a bright metal condition.
At the conclusion of back gouging QC Technician William Sherwood performed Magnetic Particle Testing on the back gouged area of the above-mentioned weld at a test frequency of 100% of the weld length. No indications were noted. Upon the completion of Sherwood’s test this QAI performed Magnetic Particle Testing on the weld at a frequency of 10% the total weld length. No indications noted.

This QAI observed Welder Tran Chau (ID#3139) using a rosebud torch to preheat floor beam splice PP121-W2.

4-BW1 to a QC recorded, QA verified temperature of 150F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC Tony Sherwood recording preheat temperature whenever there was a stop in work.

QAI witnessed the welding of Floor Beam Splice PP121-W2.4-BW1 by welder Tran Chau utilizing the Shield Metal Arc Welding Process to the QC recorded QA verified parameters of Welding Procedure Specification ABF-WPS-D15-1030-1.
Mr. Chau completed the first side then back gouged the back side of the weld to sound metal using a 4" angle grinder and power wire brush to clean the back gouge to a bright metal condition.

At the conclusion of back gouging QC Technician William Sherwood performed Magnetic Particle Testing on the back gouged area of the above-mentioned weld at a test frequency of 100% of the weld length. No indications were noted. Upon the completion of Sherwood's test this QAI performed Magnetic Particle Testing on the weld at a frequency of 10% the total weld length. No indications noted.

This QAI observed Welder Mike Jiminez (ID#4671) using a rosebud torch to preheat floor beam splice PP123-W2. 1-BW1 to a QC recorded, QA verified temperature of 150F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC Tony Sherwood recording preheat temperature whenever there was a stop in work.

QAI witnessed the welding of Floor Beam Splice PP123-W2.1-BW1 by welder Mike Jiminez (ID#4617) utilizing the Shield Metal Arc Welding Process to the QC recorded QA verified parameters of Welding Procedure Specification ABF-WPS-D15-1030-1.

Mr. Jiminez completed the first side then back gouged the back side of the weld to sound metal using a 4" angle grinder and power wire brush to clean the back gouge to a bright metal condition.

At the conclusion of back gouging QC Technician William Sherwood performed Magnetic Particle Testing on the back gouged area of the above-mentioned weld at a test frequency of 100% of the weld length. No indications were noted. Upon the completion of Sherwood's test this QAI performed Magnetic Particle Testing on the weld at a frequency of 10% the total weld length. No indications noted.

QAI witnessed the welding of Floor Beam Splice 124.5-W2.2-BF1 by welder Steven Davis (ID#7889)utilizing the Shield Metal Arc Welding Process to the QC recorded QA verified parameters of Welding Procedure Specification ABF-WPS-D15-1030-1.

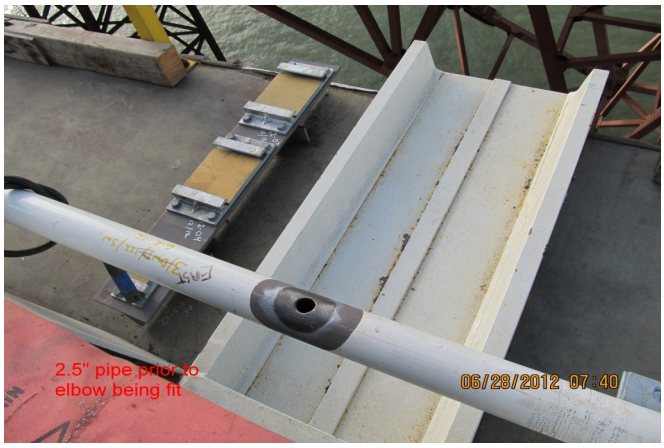
Mr. Davis completed the first side then back gouged the back side of the weld to sound metal using a 4" angle grinder and power wire brush to clean the back gouge to a bright metal condition.

At the conclusion of back gouging QC Technician William Sherwood performed Magnetic Particle Testing on the back gouged area of the above-mentioned weld at a test frequency of 100% of the weld length. No indications were noted. Upon the completion of Sherwood's test this QAI performed Magnetic Particle Testing on the weld at a frequency of 10% the total weld length. No indications noted.

QAI witnessed the welding of Longitudinal Stiffener by welder Eddie Brown (ID#9331) utilizing the Shield Metal Arc Welding Process to the QC recorded QA verified parameters of the applicable Welding Procedure

Specification .
Mr. Brown completed the first side then back gouged the back side of the weld to sound metal using a 4” angle grinder and power wire brush to clean the back gouge to a bright metal condition.

At the conclusion of back gouging QC Technician William Sherwood performed Magnetic Particle Testing on the back gouged area of the above-mentioned weld at a test frequency of 100% of the weld length. No indications were noted. Upon the completion of Sherwood’s test this QAI performed Magnetic Particle Testing on the weld at a frequency of 10% the total weld length. No indications noted.



Summary of Conversations:
There were general conversations with Quality Control Inspector Fred Michaels, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift. All observations were relayed to Danny Reyes and Bill Levell.

Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

Inspected By:	Daggett,Matt	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer